

Date: Tuesday, 08/07/2008 9:18:17 AM  
User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 40355		
Estimate Number	: 11167		
P.O. Number	:	Part Number	: D32783
This Issue	: 08/07/2008 S.O. No. :	Drawing Number	: D3278 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 38935	Material	:
Written By	:	Due Date	: 30/08/2008 Qty: 50 Um: Each
Checked & Approved By	: <u>JUL 08.7.08</u>		
Comment	: Est. A 04.04.19 New issue KJ/JLM Est B 07.09.06 Rev C dwg EC Verified by: JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRLNS0125	Black Delrin Sheet .125
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Comment: Qty.: 0.0361 sf(s)/Unit Total : 1.8060 sf(s)

Black Delrin

Material: Black Delrin/UHMW 0.125" thick

(M-DELRIN-S0.125x30.0)

Identify for D3278-3

Batch: 101657

B 8-7-18

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3278

Dwg Rev: CProg Rev: C

B 8-7-18

(66)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-7-18

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

500/07/18

(x66)

counters

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 08/07/2008 9:18:17 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 40355

Part Number: D32783

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



PT5

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C'sink as per dwg D3278

2-Deburr

EP 08/07/28 (65) counted!

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/28 (x60)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 8/

8/7/29 (x65) 50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/30

Job Completion



mf 08-07-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3278-3 PAR #: N/A Fault Category: Prod / Prod Ass <sup>decl # 5001</sup> NCR: Yes No DQA: D Date: 08/07/30  
D3278041 QA: N/C Closed: D Date: 08/07/30

NCR: <u>40355</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/07/30</u>	<u>50</u>	<u>Drilling C'sink the counter sink is the Decd on 20 parts. RC Human error</u>	<u>[Signature]</u>	<u>Scrap and Destroy no replace Qty (2)</u>	<u>[Signature]</u> <u>08/07/30</u>	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>08/07/30</u>

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40355
<b>Description:</b> Spacer		<b>Part Number:</b> D3278-3
<b>Inspection Dwg:</b> D3278	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.98	+/-0.030	1.993	X			
1.98	+/-0.030	1.993	X			
1.480	+/-0.005	1.478	X			
0.250	+/-0.010	0.250	X			
1.480	+/-0.005	1.478	X			
0.250	+/-0.010	0.250	X			
Ø0.098	+0.005/-0.000	0.099	X			
R0.13	+/-0.030	0.13	X			
0.125	+/-0.010	0.127	X			

<b>Measured by:</b> JB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-7-18	<b>Date:</b> 08/7/18	<b>Date:</b>	N/A

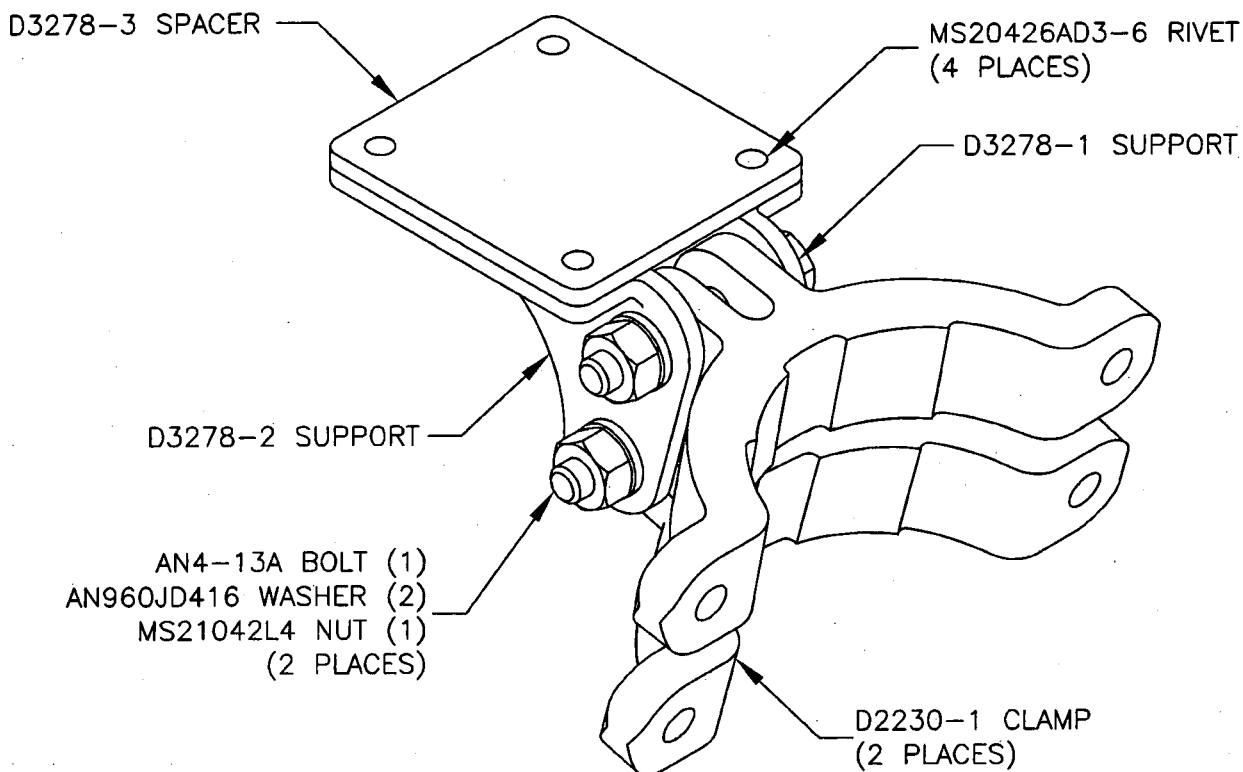
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.02.02	Dwg updated per JLM	KJ/JLM	
D	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	JB

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

**RELEASED**  
*07-08-08*

## D3278-041 SUPPORT ASSEMBLY

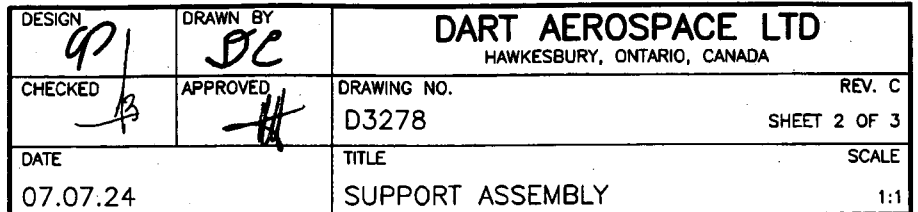


Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

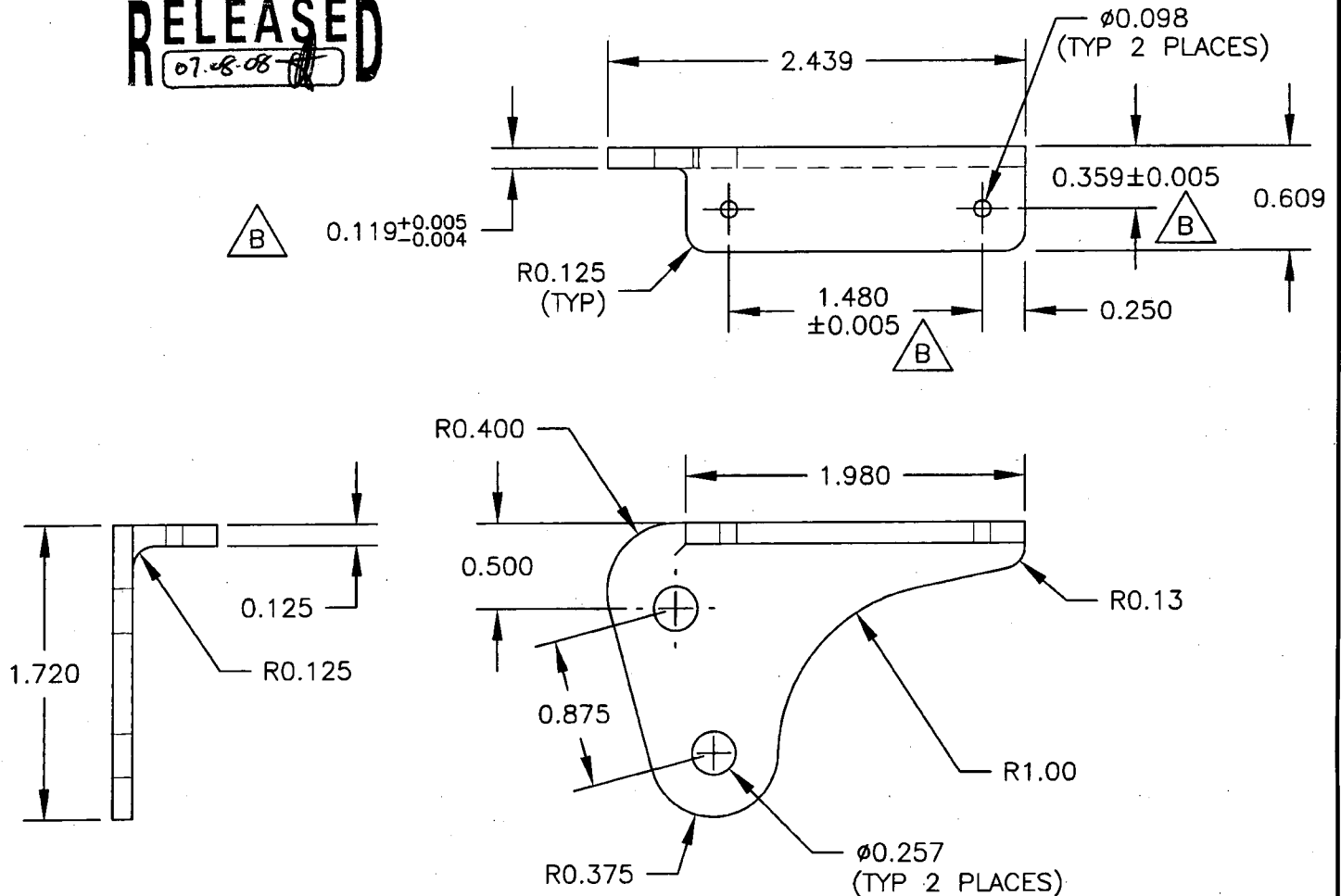
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RELEASED  
07-08-08



**D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

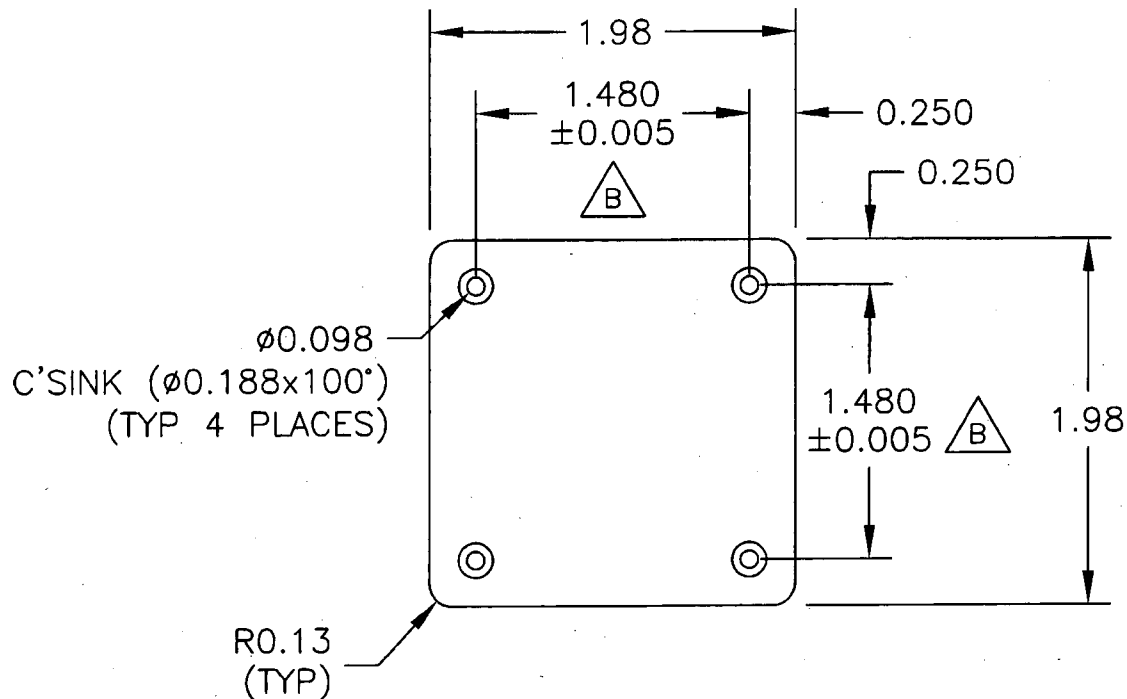
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**DART**

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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